

Work Order ID 151169

151169

Page 1

Monday, September 12, 2016 1:14:17 PM

Item ID: D3997-37 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Placard
 Start Date: 9/19/2016 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 9/27/2016 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 Date: SEP 12 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3997	B								
100		0.00							
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>33627</u>								
	Manufacture as per Dwg D3997								
	Possible Supplier: Studio Lettrage								
	Material release note required								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.02							
Packaging									
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									

6 SEP 12 2016 DAS 13 9-89

6x SP16-9-26

6 DAS 38 9-89 SEP 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition																			
				Completed By																	
				Lead hand / Supervisor Approval Verification																	
				QC / QA Coordinator Approval																	
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OTHER : _____																					

Work Order ID 151169***151169***

Page 2

Monday, September 12, 2016 1:14:17 PM

Item ID: D3997-37

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Placard

Start Date: 9/19/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 9/27/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>Stokey</u>	0.00							
130									
Packaging	Memo	0.01							
Packaging	***ONE YEAR EXPIRED DATE FROM RECEIVING: <u>SEP 26 2017</u> ***								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.10							
Quality Control									

p SEP 26 2016 DAS 9-89

10/19/2017

DAS
21
9-89 SEP 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER : _____																									

Picklist Print

Monday, September 12, 2016 1:14:21 PM

Page 1

Work Order ID: 151169

151169

Parent Item: D3997-37

D3997-37

Parent Item Name: Placard

Start Date: 9/19/2016

Required Date: 9/27/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP rev A 10.01.13 new issue Prelim EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3997-37P		Purchased	No				Each	0.0000		6			
D3997-37P									**				
Placard													

6x 8p16-9-26

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

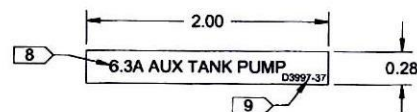
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coor. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment	☐		No Re-verification	☐		Pressure/Forced	☐
Design	☐		Operator	☐		Bending	☐
Doc/Data	☐		Offset/Setup	☐		Centre Not Concentric	☐
Equip/Tooling	☐		Supplier	☐		Cracks	☐
Handling/Pre	☐		Training	☐		Crimp/Kink/Ripple/Wave	☐
Material	☐		Use for Testing	☐		Cuffs	☐
Internal Transport	☐		Poor Information	☐		Crushing	☐
Tribal Knowledge	☐		Rushing	☐		Heat Treat	☐
LOA	☐		Product Improvement	☐		Wave/Twist in Tube	☐
Substation	☐		Process Improvement	☐		Marks/Chatter	☐
Past Expiry Date	☐		Manufacturing Process	☐		OTHER :	☐
Misidentified	☐		Past Due	☐			

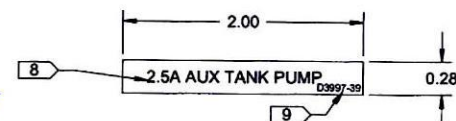
DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D3997-37	JCA-M47-P21
D3997-39	JCA-M47-P22
D3997-41	JCA-M47-P23
D3997-43	JCA-M47-P24

PART NUMBER	INSTALLATION INSTRUCTIONS
D3997-37	ADJACENT TO CB INSTALL
D3997-39	ADJACENT TO CB INSTALL
D3997-41	ON BACK OF D3997-25/-27
D3997-43	ON TANK EARTH POINT

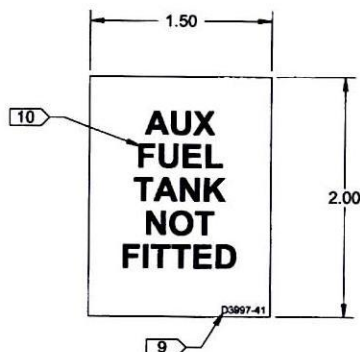
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151169 ML5
1609-12



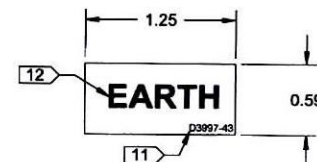
D3997-37 PLACARD



D3997-39 PLACARD



D3997-41 PLACARD



D3997-43 PLACARD

- NOTES:
- 1) MATERIAL: 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY AS PER NOTES 8-12 ON SHEET 6
 - 7) WEIGHT: LESS THAN 0.01 LBS
 - 8) 10 PT FONT, WHITE TEXT ON BLACK BACKGROUND
 - 9) 6 PT FONT, WHITE TEXT ON BLACK BACKGROUND
 - 10) 20 PT BOLD FONT, WHITE TEXT ON BLACK BACKGROUND
 - 11) 6 PT FONT, BLACK TEXT ON WHITE BACKGROUND
 - 12) 20 PT BOLD FONT, BLACK TEXT ON WHITE BACKGROUND

RELEASED
2014-06-11

APPROVED

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AP	DRAWING NO. D3997	REV. B
MFG. APPR.	JLM		SHEET 6 OF 6
APPROVED	MP	TITLE PLACARD	SCALE NTS
DE APPR.	DS		
DATE	13.11.05	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO33627**

Purchase Order Date 9/12/2016

PO Print Date 9/12/2016

Page Number 3 of 5

Order From :

VC-STU001

Ship To : DART AEROSPACE LTD

STUDIO DE LETTRAGE 2001
210 MAIN WEST
HAWKESBURY, ON K6A 2H6
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

613 632 5449

Ship To Contact

Ship To Phone

Ship Via:

Yours ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Total: \$80.00

7 D3997-33P

Placard

9/19/2016

6.00

\$13.33

\$80.00

Yes

Each

9/19/2016

AS PER DWG D3997 REV. B
B151167

Line Total: \$80.00

8 D3997-35P

Placard

9/19/2016

6.00

\$13.33

\$80.00

Yes

Each

9/19/2016

AS PER DWG D3997 REV. B
B151168

Line Total: \$80.00

9 D3997-37P

Placard

9/19/2016

6.00

\$13.33

\$80.00

Yes

Each

9/19/2016

AS PER DWG D3997 REV. B
B151169

Sp16 9-26

Note:

9/12/2016

STUD!O

210 Main Street West
Hawkesbury, ON K6A 2H6
Phone # 613-632-2001

Invoice

Date	Invoice #
9/22/2016	43063

Invoice To

Dart Aerospace Ltd
1270 Aberdeen
Hawkesbury
Ontario
K6A 1K7

Ship To

P.O. No.	Terms	Rep	Ship	Via	F.O.B.	Project
			9/22/2016			

Quantity	Item	Description	Price Each	Amount
6	4005	D3997-9P.	13.33	79.98
6	4005	D3997-13P.	13.33	79.98
6	4005	D3997-15P.	13.33	79.98
6	4005	D3997-21P.	13.33	79.98
6	4005	D3997-23P.	13.33	79.98
6	4005	D3997-31P.	13.33	79.98
6	4005	D3997-33P.	13.33	79.98
6	4005	D3997-35P.	13.33	79.98
6	4005	D3997-37P.	13.33	79.98
6	4005	D3997-39P.	13.33	79.98
6	4005	D3997-41P.	13.33	79.98
		Attn: Chantal Ref: 18672		
SP/6-9-24				

Subtotal \$879.78

Sales Tax \$114.37

Thank you for your business.

Total \$994.15

PRODUCT DATA SHEET



Avery® IPM I™ 7112

issued: 15/04/2002

Introduction

Avery IPM I 7112 is a white monomeric calendered removable self-adhesive vinyl for use on the Idanit 162Ad inkjet printer, providing good machine runnability. Because of its cost efficiency and good removability, Avery IPM I 7112 is recommended for a wide range of short term applications on flat substrates requiring easy and clean removal.

Description

Film : 100 micron gloss white monomeric calendered vinyl
Adhesive : **removable**, acrylic based
Backingpaper : kraft paper, 140 g/m²

Conversion

Avery IPM I 7112 is specially developed for use on the Idanit 162Ad and Idanit Novo inkjet printer and has been officially approved by Idanit using BL and Magic inks.

Uses

- Interior & exterior signs.
- Window decoration.
- Temporary promotional and point of sale advertising and all.
- applications to flat or regular surfaces that require removability.

Features

- Good printability and handling on Idanit 162Ad.
- Easy conversion.
- Most economical solution for short term outdoor graphics.
- Easy and clean removal (up to 1 year).



www.averygraphics.com

Graphics Division
Rijndijk 86, P.O. Box 116
2394 ZG Hazerswoude - The Netherlands
Tel +31 71 3421500 - Fax +31 71 3421538

PRODUCT CHARACTERISTICS

Avery® IPM I™ 7112

Physical properties

Features	Test method ¹	Results
Caliper, facefilm	ISO 534	100 micron
Opacity	ISO 2471	92%
Dimensional stability	DIN 30646	0.3 mm max.
Adhesion, initial	FINAT FTM-1, stainless steel	225 N/m
Adhesion, ultimate	FINAT FTM-1, stainless steel	400 N/m
Flammability		Self extinguishing
Shelf life	Stored at 22° C/50-55 % RH	2 years
Removability		up to 1 year*
*Not when applied to: Nitrocellulose paints, ABS, Polystyrene, screenprinting inks (fresh), certain types of PVC		
Durability, unprinted	Vertical exposure	2 years

Temperature range

Features	Results
Minimum application temperature:	≥ 0° C
Temperature range:	- 40 to +100 °C

Important

Information on physical and chemical characteristics is based upon tests we believe to be reliable. The values listed herein are typical values and are not for use in specifications. They are intended only as a source of information and are given without guarantee and do not constitute a warranty. Purchasers should independently determine, prior to use, the suitability of this material to their specific use. All technical data are subject to change.

Warranty

Avery® branded materials are manufactured under careful quality control and are warranted to be free from defect in material and workmanship. Any material shown to our satisfaction to be defective at the time of sale will be replaced without charge. Our aggregate liability to the purchaser shall in no circumstances exceed the cost of the defective materials supplied. No salesman, representative or agent is authorised to give any guarantee, warranty, or make any representation contrary to the foregoing.

All Avery® branded materials are sold subject to the above conditions, being part of our standard conditions of sale, a copy of which is available on request.

1) Test methods

More information about our test methods can be found on our website.

2) Durability

The durability is based on middle European exposure conditions. Actual performance life will depend on substrate preparation, exposure conditions and maintenance of the marking. For instance, in the case of signs facing south; in areas of long high temperature exposure such as southern European countries; in industrially polluted areas or high altitudes, exterior performance will be decreased.



www.averygraphics.com

Graphics Division

Rijndijk 86, P.O. Box 118
2394 ZG Hazerswoude - The Netherlands
Tel +31 71 3421500 - Fax +31 71 3421538

******CERTIFICATE of CONFORMITY******

Customer:

Purchase Order N°:

Packing Slip N°:

Part N°:

Serial N°:

Description: D3997-9P, D3997-13P
D3997-15P, D3997-21P, D3997-23P
D3997-31P, D3997-33P, D3997-35P

Quantity: 6 of each.

Certification: D3997-37P, D3997-39P, D3997-41P

We hereby certify that:

1. The above listed items were manufactured, repaired and/or inspected in accordance with applicable drawings and/or specifications;
2. All work was accomplished in accordance with the Dart Aerospace Purchase Order;
3. Results of all inspections, chemical or physical tests, as well as other evidence, which shows the acceptability of raw materials, parts and/or assembly components are on file and available for inspection at any time.

Authority:

APPROVAL:

Signature:

Title:

DATE:

Avery
Grace Balthasar
[Signature]
OWNER

Sept 23/16